

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014743**Date Inspected:** 31-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Tu Jun	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	Tower Components	

Summary of Items Observed:

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 2A located on Lift-5 Splice Plate Stiffener SSD1 – SPSA5 – 16. Welder is identified as 050289.

ZPMC Quality Control (QC) Inspector is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 1B located on Lift-5 Splice Plate Stiffener SSD1 – SPSA5 – 19. Welder is identified as 052930.

ZPMC Quality Control (QC) Inspector is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Flux cored Arc Welding (FCAW):

Weld joint # 83 located on Shear Plate ED1 – A27B/E. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld joint # 70 located on Shear Plate ED1 – A27B/E. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2331 – Tc – P4 – F.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 1A located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 2. Welder is identified as 044551. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1. (See attached photo)

Submerged Arc Welding (SAW):

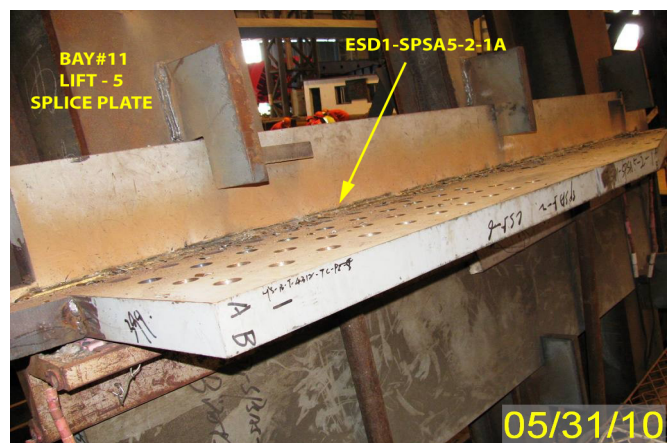
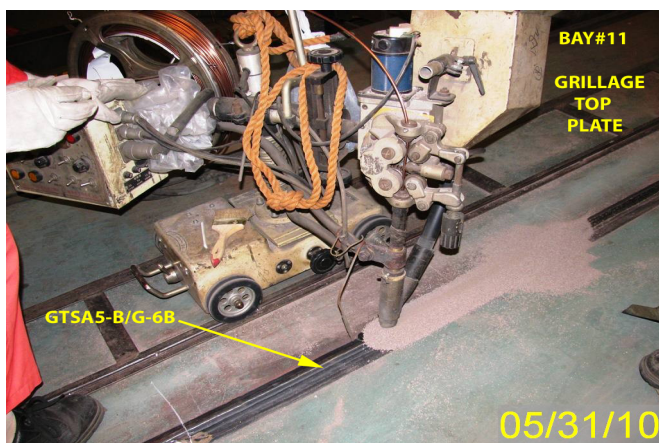
Weld joint # 6B located on Grillage Top Plate GTSA5 – B/G. Welder is identified as 044550. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2. (See attached photo)

Weld joint # 3B located on Grillage Top Plate GTSA5 – B/G. Welder is identified as 042195. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2.

MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY EAST TOWER LIFT-1

This QA Inspector carried out the measurements on East Tower Lift-1 Exterior side to check the distance from the edge of the base plate anchor bolt holes to the side of the type-2 bearing stiffeners for skin 'A'; 'B'; 'C'; 'E'. Measurements were recorded on the data sheet and submitted to the assigned task leader.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep
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Quality Assurance Inspector

Reviewed By:	Clifford,William
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QA Reviewer
